

Date: Thursday, 30/10/2008 1:45:53 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicop	Job Number : 43100	Estimate Number : 13603	P.O. Number :	This Issue : 30/10/2008	S.O. No	Prsht Rev. : NC	First Issue : / /	Previous Run : 42295	Written By : _____	Checked & Approved By : _____	Comment : Est. Rev. A New Issue 08.09.25 DL	
						Drawing Name : VERTICAL TUNNEL LOWER						
						Part Number : D38227						
						Drawing Number : D38227 UNDER REVIEW 08.11.08						
						Project Number : IN0002						
						Drawing Revision : A UNDER REVIEW						
						Material : MKYDEX6185S80P362015						
						Due Date : 06/11/2008	Qty: 2	Um: Each				

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

30/10/2008 Dh

cancel.

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MKYDEX6185S80P362015

Kydex velour matte, ivory



Comment: Qty.: 5.4170 sf(s)/Unit Total : 10.8340 sf(s)
Kydex velour matte, ivory

M 109703

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/08 Dh

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/04 Dh

4.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-7 and folio (FTA 9396 Prototype) using tool DT 9396

Dwg. Rev. A. UNDER REVIEW.
Folio Rev. A.

08/11/04 Dh

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/04 Dh

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL LOWER

Job Number: 43100

Part Number: D38227

Job Number:



Seq. #:

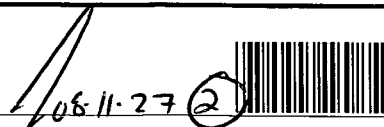
Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

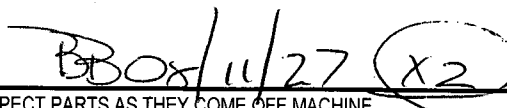
HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions



8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08.12.01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A.

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.01 Prototype

Job Completion



W 08.12.24
POSITIVE RECALL

EFFECTIVE 08.10.30 AUTH U

RELEASED DATE _____

Cancel
H.

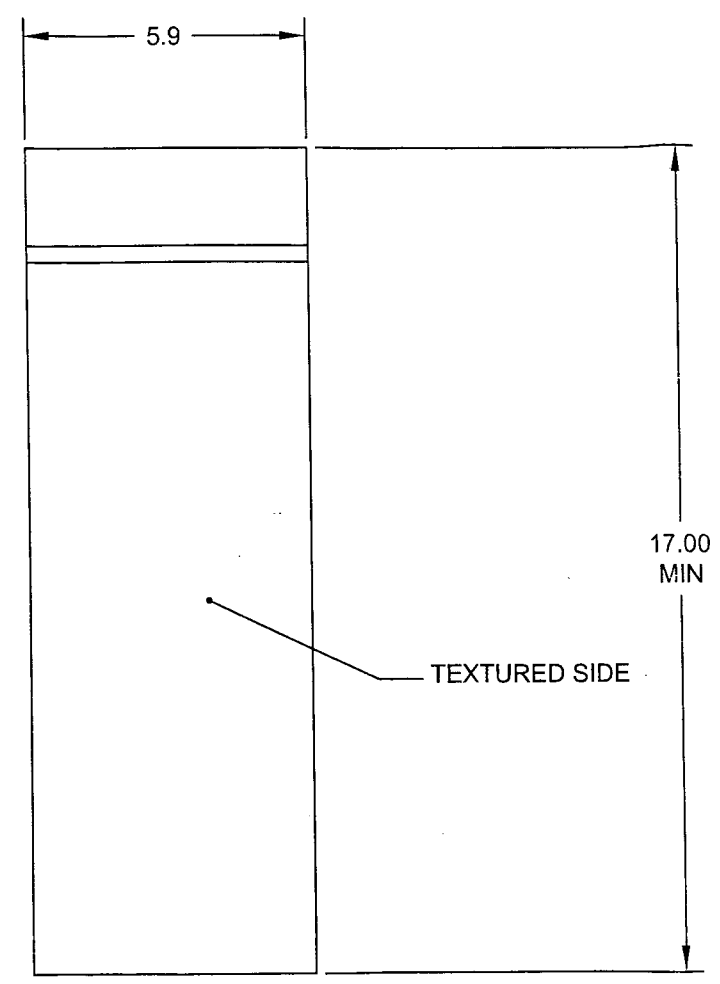
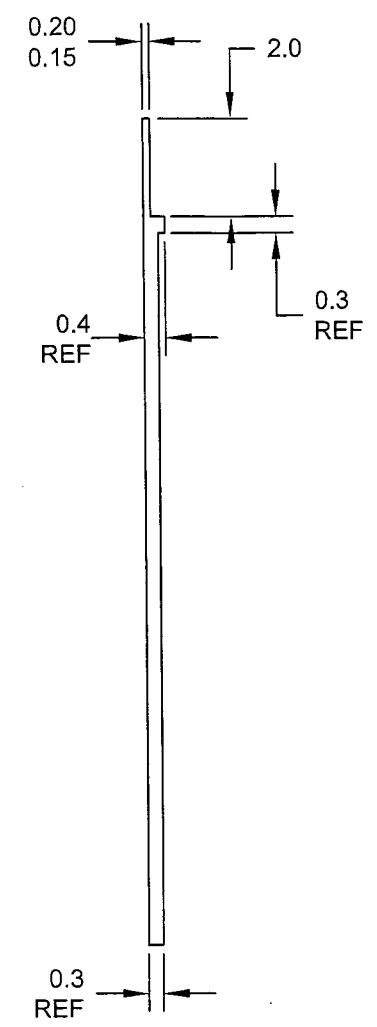
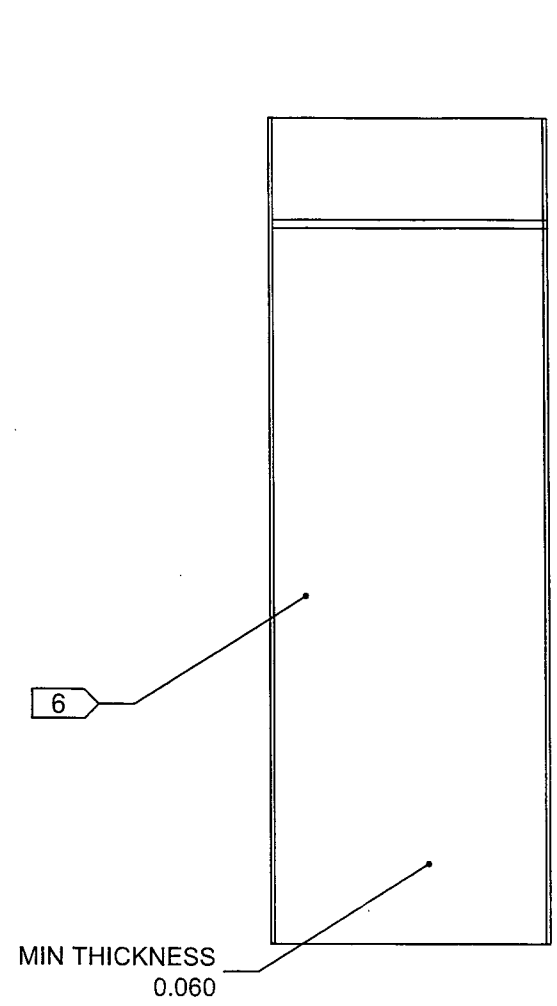
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-7 VERTICAL TUNNEL, LOWER

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 08.11.07 *RS*

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
 (REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-7" WITH VIBRATING STYLUS
 - 7) WEIGHT: 0.48 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022

DESIGN	<i>RS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RS</i>		
CHECKED	<i>RS</i>	DRAWING NO.	REV. A
MFG. APPR.		D3822	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date:

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

No

Release Note Attached:

Yes

~~No~~

N/A

Invoice:

Yes

No

Waybill Attached:

Yes

No

Receipt:

Cash

Cr

Shipment Complete

Yes

No

N/A

QC6 Inspection

Work Order

N/A

N/A

Discrepancies

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin:

Location



SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 8/20/27

08/20/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

JON CALDWELL
BRANCH MANAGER

DART AEROSPACE LTD		Work Order: 43100
Description: Vertical tunnel lower / Prototype.		Part Number: D3822-7
Inspection Dwg: D3822	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓	✗		wrong column
Texture Retention	✓	✗		
Material imperfections such as bumps, cracks, voids, scratching	✓	✗		

Measured by: JB

Date: 08/11/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.00	min	17.032	✓			
5.9	± 0.100	5.890	✓			
2.0	± 0.100	2.025	✓			
0.20 → 0.15		0.175	✓			
0.4 (Ref)		0.460	✓			
0.3 (Ref)		0.27	✓			Ref. but within tolerance
0.3 (Ref)		0.3	✓			
0.06	min	0.067	✓			

Measured by: JB

Date: 08/11/27

Audited by: [Signature]

Date: 08.11.27

Prototype Approval: PA

Date: 09.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	